

S128095



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D212-664-101
Job Sheet 186378



Part No: D212-664-101

Job Qty: 1 ea

Part Name: Fwd Crosstube - High



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/15/18

Job Tracking No: RA488

Due Date: 11/16/18

Created By: Michelle Gagnon-Donovan

Type: Return

Description: SN: S110064

Note: D212-664-141 REV E/ IIN-D212-664 REV.J IPP Rev:E 04.02.16 Reformat KJ/DS IPP Rev:F 06-03-29 Remove Coments on Pick List JLM IPP Rev:G 07-04-30 As per Rev C JLM IPP Rev:H 11.04.26 inspection strip ecn 11-549 EC verf by:DD IPP REV:I 14.05.27 AS PER ECN 14-570 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	11/16/18	11/16/18	0.00	0.00	Start Up Stores/Pkg-1		ms 18.11.15
110	Rework	1 pcs	11/16/18	11/16/18	0.00	0.00	Small Fab		Bp / DPC 18.11.15
130	Rework	1 pcs	11/16/18	11/16/18	0.00	0.00	Handfinish - 4 - 1 - B4B		Bp / DPC 18.11.15
140	Rework	1 pcs	11/16/18	11/16/18	0.00	0.00	Handfinish - 1 - 1 B4B.		AS 18-11-22
200	SprayPaint	1 pcs	11/16/18	11/16/18	0.00	0.00	Spray Paint		AS 18-11-23
210	QC	1 pcs	11/16/18	11/16/18	0.00	0.00	QC14		38 DAS
230	QC	1 pcs	11/16/18	11/16/18	0.00	0.00	QC5		9-89 38
240	Packaging	1 pcs	11/16/18	11/16/18	0.00	0.00	Packaging1-3		NOV 30 2018
250	QC	1 pcs	11/16/18	11/16/18	0.00	0.00	QC4		NOV 30 2018
260	Packaging	1 pcs	11/16/18	11/16/18	0.00	0.00	Packaging3-1		NOV 30 2018
265	DC	1 pcs	11/16/18	11/16/18	0.00	0.00	DC		ms 18.11.30
270	QC21-FG	1 Ea	11/16/18	11/16/18	0.00	0.00	QC21		ms 18.11.30

Part Op 110 - Disassemble crosstube, remove support and scrap clamps.

Descriptions: 130 - Strip entire tube using paint stripper. Grind entire tube to remove damage from shipper.

140 - Alodine, paint and assemble as per qsi. Reinstall support if not damaged during disassembly, otherwise replace. DO NOT PUT TUBE IN ACID

200 - *** WEAR LATEX GLOVES WHEN HANDLING CROSTUBE*** 1-Prime inside & outside crosstube as per QSI 005 4.2 BATCH: 138962 2- After painting remove masking and apply matte clear coat per QSI005 4.2 3- MASK UNDERSIDE OF CROSTUBE AS SHOWN ON DWG BEFORE PAINTING 4 -Paint Outside of Tube as per Dart QSI 005 4.2 clear 138875 Paint 138956

210 - Then,Wrap in plastic bag to protect from scratches

230 - ***RE-CHECK TORCQUE ON CLAMP AFTER PROSEAL HAS CURED FOR 72HOURS AS PER DWG.***

250 - ***VERIFY BY _____ BATCH # TO MATCH W/O _____

260 - Identify and pack for shipping as per PPP D212-664-101 Location : FG094

265 - Photocopy bluefile and create labels as per PPP D212-664-101 CHG006 ✓

205 - Proseal 5096 394 exp 3/19

170 outsource

180 Packaging

190 Qc

205 Crosstubes Rework

Sky002-vc

Packaging2

Qc5

Crosstubes

P0011806 CT 18-11-29

NOV 23 2018

18-11-27

DART
AEROSPACE

Container No: S128095



Part: D212-664-101

Job No: 186378

Serial No/Batch: s110064

Revision: E/J

Inspector:

Exp Date:

Instructions: TC STC SH01-9 Issue 3, FAA STC SR01298NY 09/01/08, EASA STC

1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D212-664-101	Fwd Crosstube - High	1 Ea (1 ea)	90-Start up Operation	5110064
AN6-35A	Bolt	4 Ea (4 ea)	240-Packaging	5123681
AN6-36A	Bolt	4 Ea (4 ea)	240-Packaging	5098035
D3428-1	Placard	1 Ea (1 ea)	240-Packaging	5089521
MS21042L6	Nut	6 Ea (6 ea)	240-Packaging	5104002
NAS1149D0663J	Washer	18 Ea (18 ea)	240-Packaging	5098765

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D212-664-101 5110064	①	4	0
240-Packaging	AN6-35A	4	147	0
	AN6-36A	4	85	0
	D3428-1	1	49	0
	MS21042L6	6	266	0
	NAS1149D0663J	18	858	0
	MS21920-25 5122604(7)			
	D3595-063-450 5127254(1)			

crosstube

Part Specifications

Specifications could not be found.

Plex 11/15/18 9:12 AM Dart.Gagnon.Michelle

Inspection Sheet Complete RA488

Customer QA Ref #

0

Part Number	Original Batch / Serial # / Ctrl #	Original Revision #	Quantity	Part Complete	Rev/CHG Current	New Paperwork	New Labels	Disposition	Original Container #	New (Receiving) Serial #	New Job #	Work order instructions
D212-664-101	S110064, S110095		2	☒ es	☒ es	☐ es	☒ es	DAMAGED/REPAIRABLE	S110064	S125712	customer supplied	Kit complete with damage to package and both crosstubes. Never arrived at customer. See attached photos. S110064: Disassemble crosstube, remove support, and scrap clamps. Strip entire tube using paint stripper. Grind entire tube to remove damage from shipper (damage appears to be less than .005"). Alodine, paint and assemble as per qsi. Reinstall support if not damaged during disassembly, otherwise replace. Do not put tube in acid.
0			0	☐ es	☐ es	☐ es	☐ es		S110095	S125713		S110095: Clean and put back in stock.
0			0	☐ es	☐ es	☐ es	☐ es					
0			0	☐ es	☐ es	☐ es	☐ es					
0			0	☐ es	☐ es	☐ es	☐ es					
0			0	☐ es	☐ es	☐ es	☐ es					

QC Approval: AT

Date: 12-Nov-18

Special Return/Rework Instructions:



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041806**

Supplier: SKY002-VC
Skyservice
6120 Midfield Road
Mississauga
ON
L5P 1B1 Canada
Phone: 905-678-5636
Fax: 905-678-5841

PO No: PO041806
PO Date: 11/21/18
Due Date: 11/28/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	184457	D4884-3	End Fitting, Eye : Various STC's Outsource process - NDT per QSI038 4.1	Firmed	-	11/28/18	4 pcs	0 pcs	4 pcs	\$68.20/pcs	\$272.80
2	183453-A	D4884-1	End Fitting, Eye : Various STC's ISSUE P/O	Firmed	-	11/28/18	6 pcs	0 pcs	6 pcs	\$68.20/pcs	\$409.20
3	182141	D212-664-201	Aft Crosstube - High : TC STC SH01-9 Issue 3, FAA STC SR01298NY 09/01/08, EASA STC EASA.IM.R.S.01304 07/03/06, DGAC MEXICO STC IA-316/2015 15/06/17 ***WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE.*** Issue P/O: LIQUID PENETRANT INSPECTION AS PER QSI 038 OR LPI AS PER ASTM 1417 LEVEL 2	Firmed	-	11/28/18	1 pcs	0 pcs	1 pcs	\$68.20/pcs	\$68.20
	183771		NOV 2 3 2018	Firmed	-	11/28/18	1 pcs	0 pcs	1 pcs	\$68.20/pcs	\$68.20
	182139		NOV 2 3 2018	Firmed	-	11/28/18	1 pcs	0 pcs	1 pcs	\$68.20/pcs	\$68.20
	182142		NOV 2 3 2018	Firmed	-	11/28/18	1 pcs	0 pcs	1 pcs	\$68.20/pcs	\$68.20
Sub Total:							4	0	4		\$272.80



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PURCHASE ORDER **PO041806**

Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	186378	D212-664-101	Fwd Crosstube - High : TC STC SH01-9 Issue 3, FAA STC SR01298NY 09/01/08, EASA STC EASA.IM.R.S.01304 07/03/06, DGAC MEXICO STC IA-316/2015 15/06/17 *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038 LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order	Firmed	-	11/28/18	1 pcs	0 pcs	1 pcs	\$68.20/pcs	\$68.20
										Grand Total:	\$1,023.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 11/21/18 3:28 PM dart.tsimiklis.chrisoula

**skyservice****Work Order Traveler**

Sky Service F.B.O. Inc.

10105 Ryan Avenue, Dorval, Quebec, H9P 1A2

TCCA AMO 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO38261	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: PQ041774
Descr:	PN:	S/N:	Qty: 1 P/O: 041806
Make:	Model:	Reg:	A/C S/N: 2 NOV 23 2018
TSN:	CSN:	TSO:	
Task: UNSCHEDULED			Sequence: 1

Work Required:

CARRY OUT NDT (LIQUID PENETRANT CRACK TEST) ON THE FOLLOWING PARTS:

P/N: D4884-3 END FITTINGS, EYE JOB SHEET# 184457 (4 ea.) ✓

P/N: D4884-1 END FITTINGS, EYE JOB SHEET# 183453-A (6 ea.) ✓

P/N: D212-664-201 AFT CROSSTUBE - HIGH

JOB SHEET# 183771 ✓ JOB SHEET# 182141 ✓

JOB SHEET# 182139 ✓ JOB SHEET# 182142 ✓

P/N: D212-664-101 FWD CROSSTUBE - HIGH

JOB SHEET# 186378 ✓

Action Taken:						Date:	Initial/Stamp:
LIQUID PENETRANT INSPECTION CARRIED OUT ON ITEMS LISTED ABOVE AS PER ASTM1417M-16						20 NOV 2018	
NO CRACK FOUND							
PEN (ZL-56, MPO13600), DEV. (SKD-S2, MPO11715), CLEANER (SKC-S, MPO19368)							
Description	Location	P/N	Qty	Batch	S/N Off	S/N On	

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature:	ACA/SCA Stamp 	Date: 20 NOV 2018
Name: CHRISTIAN BRIEN		

Change Record

PAGE 1 OF 1

Part Number: D212-664-101/-101MB

Description: CROSSTUBE INSTALLATION, HIGH FWD

[illegible]

